

Date: Tuesday, 8/28/2007 3:17:20 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	STOP
Job Number	34291A		
Estimate Number	10731		
P.O. Number	N/A	Part Number	D23243
This Issue	8/28/2007	Drawing Number	D2324 REV. C
Prsht Rev.	NC	Project Number	N/A
First Issue	N/A	Drawing Revision	C
Previous Run	32353	Material	N/A
Written By		Due Date	9/12/2007
Checked & Approved By	<u>JH</u> 08.28	Qty:	25
Comment	Est: E 03.02.28 Reformat; Incorporated D2324-3 & D2324-5 KJ/RF	Um:	20 Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0750X00750	6061-T6 Bar .75" x .75"
		Comment: Qty.: 0.5565 f(s)/Unit Total : 11.1300 f(s) 6061-T6 Bar 0.75" x 0.75" Material: 6061-T6/6511 (QQ-A-200/8) or (QQ-A-225/8) or 5052-H34 (QQ-A-225/7) or (QQ-A-250/8) (M6061T6B0.750x0.750) Batch: M10247L <u>SF 07/10/14</u>
2.0	BAND SAW	BAND SAW
		Comment: BAND SAW Cut blanks: (0.75" x 0.75") x 5.75" Long Bar <u>SF 07/10/14</u>
3.0	HAAS	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio D2324-3 and Dwg D2324 2- Deburr and Tumble to remove sharp edges Identify as D2324-3 <u>SA 07.10.21</u> <u>24</u>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>SA 07.10.21</u> <u>24</u>
5.0	QC8	SECOND CHECK
		Comment: SECOND CHECK <u>SF 07/10/21</u> <u>24</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
01/10/21	20	-1.5 tank end too short.			DA 01/10/21			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(24X)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

m/

07/10/23

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

7/10/23

(24X) SB

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

7/10/23

24X SP

(24)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2023/07/10/24

Job Completion



U 07.10.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34291A
Description: Strut	Part Number:	D2324-3
Inspection Dwg: D2324	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

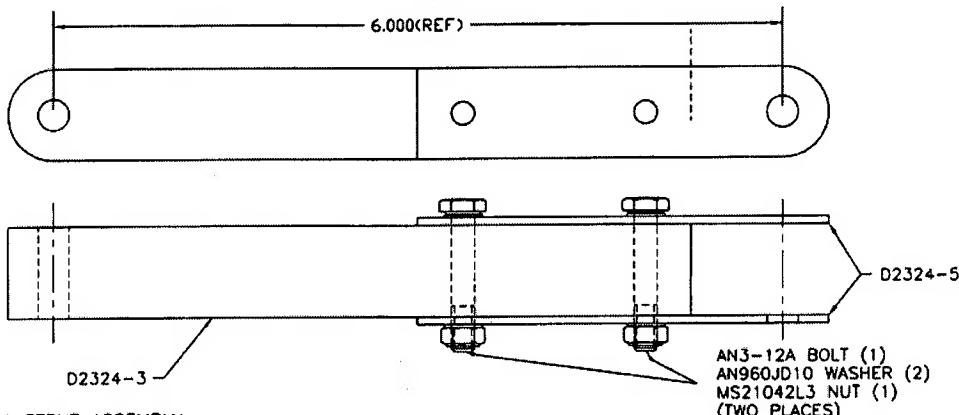
Measured by:	SA	Audited by:	S.F	Prototype Approval:	N/A
Date:	07.10.21	Date:	02/10/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.10	New Issue P/O D2324-1	KJ/JLM	
B	06.03.08	Dwg Rev changed	KJ/JLM	

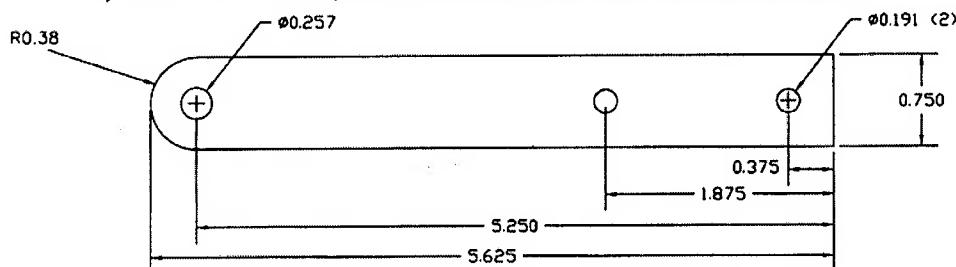
DART

DESIGN B. WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2324
DATE 04.12.14	TITLE STRUT	REV. C SHEET 1 OF 1

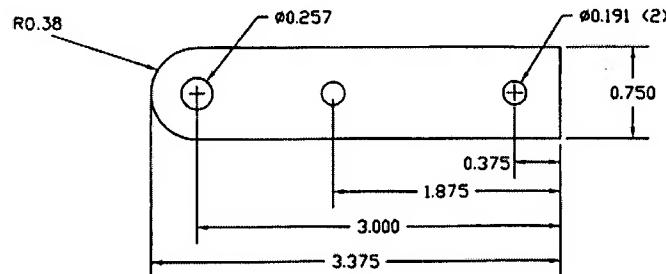
RELEASED

04.12.16 *[Signature]***D2324 STRUT ASSEMBLY**

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER

**D2324-3**

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF=DART-SPEC. M6061T680.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2324-5**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34291A

